Work Order ID 67562

Monday, March 28, 2011 11:07:23 AM

Ship 1st week April

Item ID: D4038-6 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Block

Start Date: 3/28/2011 **Start Qty:** 3.00 **Cust Item ID:**

Required Date: 4/5/2011 **Req'd Qty:** 3.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-03-28 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4038	D								
100		0.00							
Bandsaw	**Memo**	0.00				3	0		
Jeaspa Bandsaw	CUT BLANK 2.19" LONG								
105		0.00							
HAAS 1	**Memo**	0.00				3	0		
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA883 DWG REV: D FOLIO REV: AA DEBURR								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B				**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng		**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				3	ø		
	Memo	0.00 ok 11/03/31							
120 QC Quality Control	QC8- Inspect parts - second check	0.00				3	ø		
	Memo	0.00 4/3/31							
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				3	ø	11/04/11	
	Memo	0.00							

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish	0.00				3 BR		11-4-1	
	Memo	0.00							
160 Packaging Packaging	Identify as per dwg & Stock Location: GA B67550	0.00				SB 11/04/04 (3)			
	Memo	0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						11/4/4	
	Memo	0.00							

RI 11-08-4 (3)

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W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 11:07:20 AM

Work Order ID: 67562

Parent Item: D4038-6

Parent Item Name: Block

Start Date: 3/28/2011 **Required Date:** 4/5/2011

Start Qty: 3.00 **Required Qty:** 3.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.000		Purchased	No				f	11.0000		0.524211			

6061-T6 Bar 1.50 x 2.00

Location	Loc Qty	Loc Code	
MAT010	11		
110167	1		
114608	10		.524 mk 11/03/29

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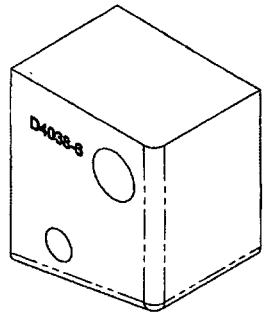
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

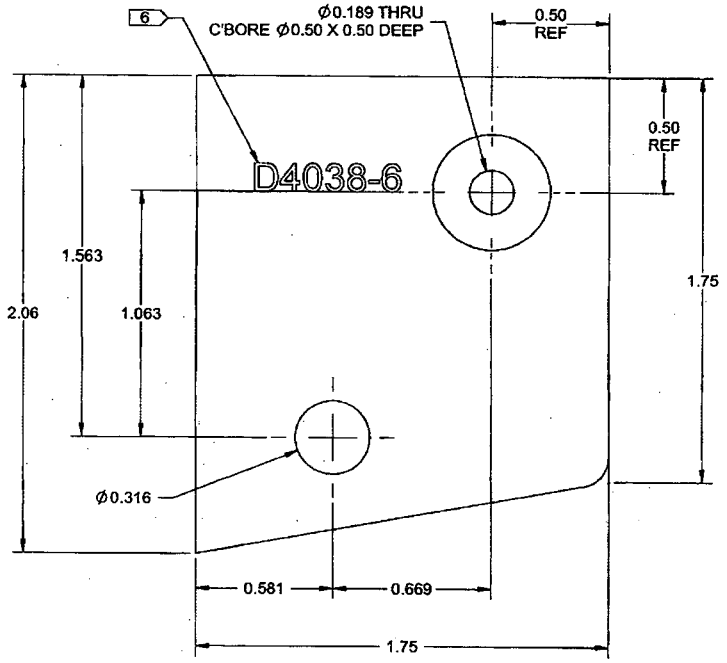
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

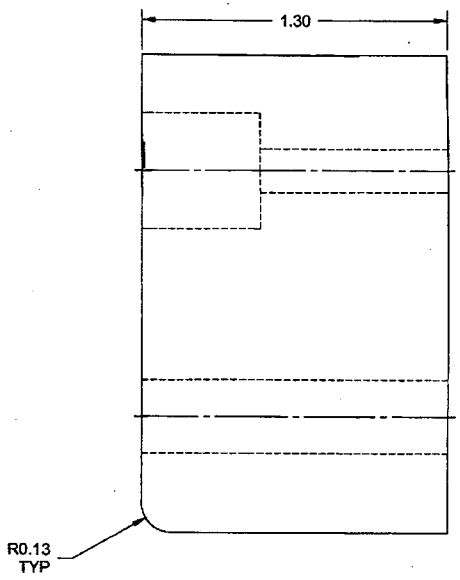
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NOTE: Date & initial all entries

#67307







RELEASED
2011-03-07

D4038-6 BLOCK

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
7) WEIGHT: 0.40 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4038 — REV. D
MFG. APPR.		SHEET 8 OF 14
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE 11.03.03		

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Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	67562
Description: Block		Part Number:	D4038-6
Inspection Dwg: D4038	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.30	+/-0.030	1.300	✓		Vern #1-7	
R0.13	+/-0.030	R.125	✓		Rad gage	
2.06	+/-0.030	2.063	✓		Vern #1-7	
1.563	+/-0.010	1.562	✓		"	
1.063	+/-0.005	1.063	✓		"	
Ø0.316	+0.006/-0.001	Ø.317	✓		"	
0.581	+/-0.010	.580	✓		"	
0.669	+/-0.005	.669	✓		"	
1.75	+/-0.030	1.751	✓		"	
1.75	+/-0.030	1.750	✓		"	
0.50	+/-0.030	.500	✓		"	
0.50	+/-0.030	.500	✓		"	
Ø0.189	+0.005/-0.001	Ø.193	✓		"	
Ø0.50 x 0.50 Deep	+/-0.030 x +/-0.030	Ø.501 X .500	✓		"	

Measured by:		Audited by:		Preliminary Approval:	
Date:	11/03/30	Date:	11/3/3	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	

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